

Date: Tuesday, 19/08/2008 4:04:24 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
<b>Job Number</b> : 41441	
<b>Estimate Number</b> : 10937	
<b>P.O. Number</b> :	<b>Part Number</b> : D29392
<b>This Issue</b> : 19/08/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2939 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : // <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 39914	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/09/2008 <b>Qty:</b> 6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUL 08-8-19</u>	
<b>Comment</b> : Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev: C As per Rev C 07-03-19 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6101001	Saddle Billet
-----	----------	---------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 Issue material from stock: 7075-T7351 (QQ-A-250/12)  
 Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length  
 Batch No: B34872 ML 08/08/31 (6)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Program part number and batch number.  
 1-Inspect part number and batch number are programmed correctly.  
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet  
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet  
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet  
 5-Deburr ML 08/08/31 (6)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet ML 08/08/31 (6)

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



**Comment:** INSPECT ALL DIM TO DIM SHEET ML 08/08/31 (6)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 19/08/2008 4:04:24 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 41441

Part Number: D29392

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



(6)

Comment: SECOND CHECK

ISTP 08/08/31

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(6)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/09/02

7.0

POWDER COATING

POWDER COATING



M1 108523



(6x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

10:40

OVEN TEMPERATURE:

320 °F

FINISH TIME:

11:40

MF 08/09/02

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(6)

Comment: INSPECT POWDER COAT

FL 08/09/02

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 430

JS 08/09/02 (x6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 41441	
<b>Description:</b> 206 Saddle, Inboard, Right side				<b>Part Number:</b> D2939-2	
<b>Inspection Dwg:</b> D2939 <b>Rev:</b> C <b>DSK:</b> <b>Rev:</b>				<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.125	.125	.123	.124	.125
B	0.100	0.140		.125	.122	.124	.124	.121
C	0.100	0.140		.112	.118	.116	.116	.116
D	0.210	0.230		.221	.222	.221	.221	.222
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.506	2.506	2.506	2.506	2.506
H	0.510	0.515		.510	.510	.510	.511	.511
I	1.572	1.582		1.576	1.577	1.577	1.577	1.577
J	2.495	2.505		2.499	2.500	2.500	2.506	2.500
K	0.257	0.262		.259	.259	.259	.259	.259
L	0.312	0.317		.315	.315	.314	.315	.315
M	0.235	0.240		.238	.236	.238	.238	.238
N	0.100	0.140		.122	.122	.122	.122	.123
O	0.540	0.560		.550	.551	.550	.550	.549
P	0.490	0.510		.503	.501	.502	.503	.503
Q	3.715	3.725		3.717	3.717	3.717	3.718	3.717
R	2.720	2.760		2.740	2.740	2.740	2.740	2.740
S	0.240	0.270		.251	.250	.250	.249	.248
T	0.100	0.180		.140	.140	.140	.140	.140
U	1.625	1.635		1.630	1.629	1.629	1.629	1.629
V	1.362	1.372		1.367	1.366	1.366	1.366	1.366
W	0.316	0.321		.320	.320	.326	.326	.320
X	1.250	1.270	<del>1.270</del>	1.260	1.260	1.260	1.266	1.260
Y	1.565	1.585	<del>1.570</del>	1.570	1.571	1.570	1.570	1.570
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
Accept/Reject								

<b>Measured by:</b> <i>gmk</i>	<b>Date:</b> 08/08/31
<b>Audited by:</b> <i>DD</i>	<b>Date:</b> 08/08/31
<b>Prototype Approval:</b> N/A	<b>Date:</b> N/A

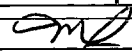

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	<i>DD</i>



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41441
<b>Description:</b> 206 Saddle, Inboard, Right side		<b>Part Number:</b> D2939-2
<b>Inspection Dwg:</b> D2939 <b>Rev:</b> C <b>DSK:</b> <b>Rev:</b>		<b>Page 1 of 1</b>

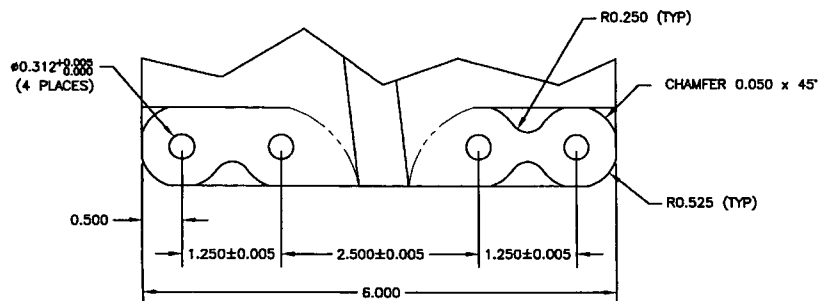
### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.125				
B	0.100	0.140		.125				
C	0.100	0.140		.115				
D	0.210	0.230		.221				
E	1.245	1.255		1.250				
F	1.245	1.255		1.250				
G	2.495	2.505		2.500				
H	0.510	0.515		.510				
I	1.572	1.582		1.577				
J	2.495	2.505		2.506				
K	0.257	0.262		.259				
L	0.312	0.317		.314				
M	0.235	0.240		.237				
N	0.100	0.140		.122				
O	0.540	0.560		.549				
P	0.490	0.510		.503				
Q	3.715	3.725		3.717				
R	2.720	2.760		2.740				
S	0.240	0.270		.249				
T	0.100	0.180		.146				
U	1.625	1.635		1.629				
V	1.362	1.372		1.366				
W	0.316	0.321		.320				
X	1.250	1.270		1.266				
Y	1.565	1.585		1.570				
Z	0.178	0.198		.188				
AA								
AB								
AC								
AD								
Accept/Reject								

<b>Measured by:</b> 	<b>Date:</b> 08/08/31
<b>Audited by:</b> 	<b>Date:</b> 08/08/31
<b>Prototype Approval:</b> N/A	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD 	

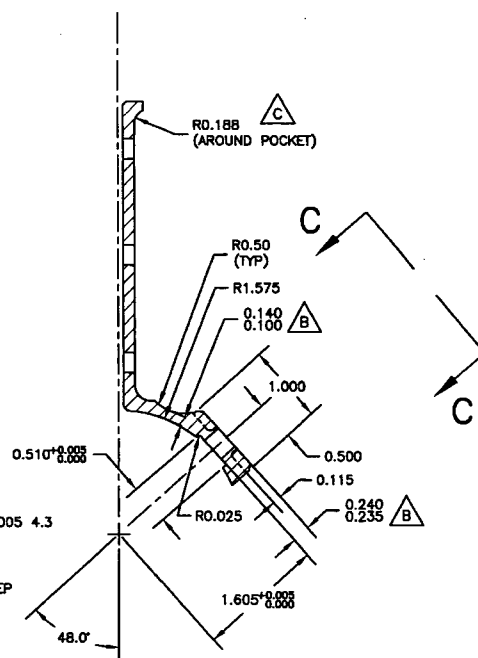


VIEW C-C

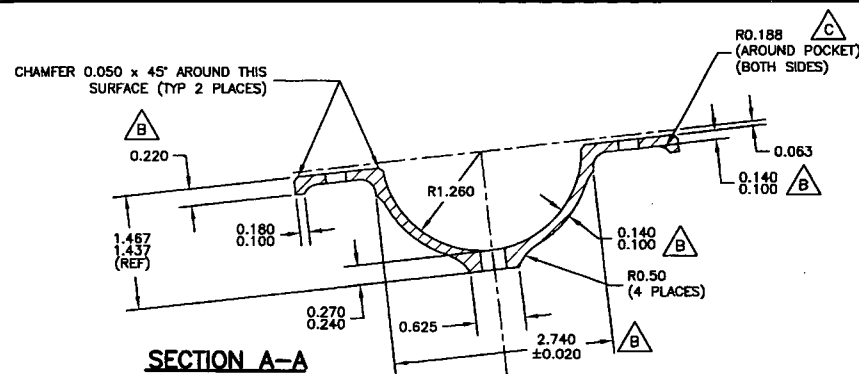
D2939-1 LH SADDLE (SHOWN)  
D2939-2 RH SADDLE (OPPOSITE)

NOTES:

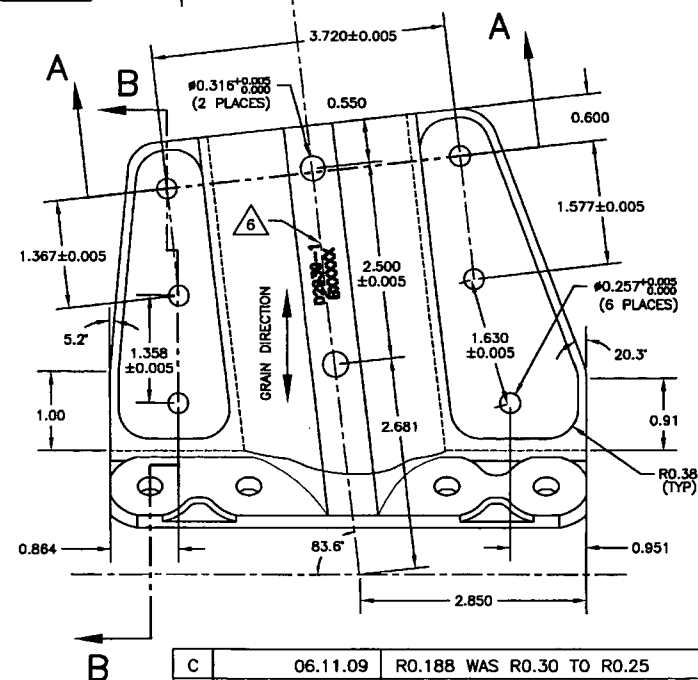
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE

COPYRIGHT © 1980 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

**DART** DART AEROSPACE USA, INC.  
BOLLEVILLE, WA

DRAWING NO. D2939  
REV. C  
SHEET 1 OF 1

SCALE  
2:3

NO. 47122  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY